

Date: Monday, 9/10/2007 1:31:39 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET	
Job Number	: 34515				
Estimate Number	: 10283				
P.O. Number	: N/A		Part Number	: D31991	
This Issue	: 9/10/2007 S.O. No. : N/A		Drawing Number	: D3199 REV B	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: B	
Previous Run	: 33672		Material	: N/A	
Written By			Due Date	: 9/30/2007 Qty: 80 Um: Each	
Checked & Approved By					
Comment	Est Rev:C	Removed Scribing	05-11-05	JLM	
	Est Rev:D	As per Rev B	06-11-24	JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet Comment: Qty.: 0.1040 sf(s)/Unit Total : 6.2370 sf(s) HB 07-09-13 304/316 0.040" SHEET Batch: m101463 X34 m101873
2.0	WATER JET	FLOW WATER JET Comment: FLOW WATER JET Cut as per Dwg D3199 Dwg Rev: B Prog Rev: B Deburr if required HB 07-09-13 (96)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 07-09-13
4.0	QC8	SECOND CHECK Comment: SECOND CHECK B3-B3 Br 02/08/17 X96
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Form as per dwg D3199 SB 07/09/20 (96)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 8/18/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/10/2007 1:31:39 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: BRACKET
Job Number: 34515		Part Number: D31991
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP
		 counters Ep 07/09/20 96
Comment: INSPECT WORK TO CURRENT STEP		
7.0	POWDER COATING	POWDER COATING M109896 M105068
		 96x
Comment: POWDER COATING Powder Coat Gey Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3		
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
9.0	PACKAGING 1	PACKAGING RESOURCE #1
		
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 53		
10.0	QC21	FINAL INSPECTION/W/O RELEASE
		 96
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion		 V 07/09/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34515
Description: Bracket	Part Number:	D3199-1
Inspection Dwg: D3199 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

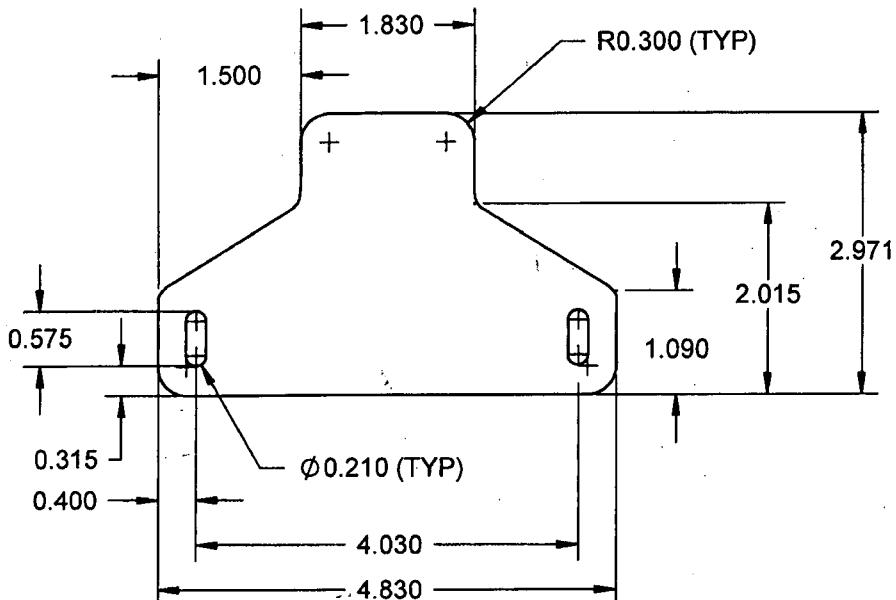
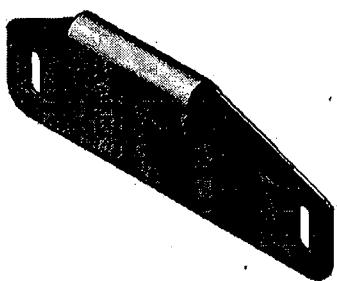
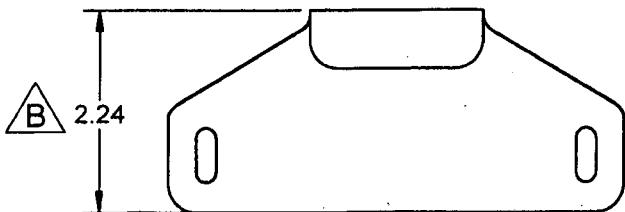
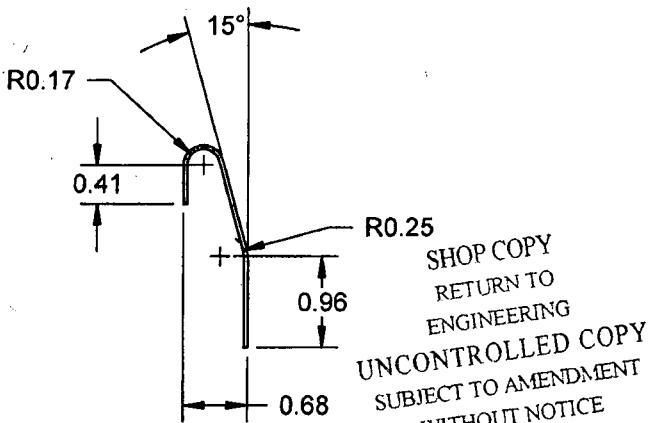
Measured by:	<u>BB</u>	Audited by:		Prototype Approval:	N/A
Date:	<u>07-09-13</u>	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.20	New Issue	KJ/JLM	
B	06.11.24	Dwg Revision revised	KJ/JLM	Z

DART

DESIGN <i>QP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CE</i>	APPROVED <i>HH</i>	DRAWING NO. D3199
DATE 06.11.01		REV. B SHEET 1 OF 1
		SCALE 1:2
REV	DATE	DESCRIPTION
A	03.08.05	NEW ISSUE
B	06.11.01	2.24 WAS 2.142; ADD FINISH; UPDATE DWG

RELEASED

06.11.01 *HH***D3199-1 FLAT PATTERN****D3199-1 BRACKET****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET 0.040" THICK PER MIL-S-5059 (REF DART SPEC. M304S) ANNEALED
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) AS PER QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3199-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

